

SUBJECT: Machine Adding Before  
Shifting - KASC Model

DATE: June 8, 1931

TO ALL OFFICES:

Rapidity in operation between the automatic clear keys and the shift keys, or the plus and minus bars and the shift keys, results in some cases in the regular mechanism making a cycle and causing a "1" to register in the counting and carrying dials before the automatic shift mechanism operates.

In other words, if a shift key is depressed during the oscillation of the regular automatic mechanism it will result in the machine locator arm, 9-1260, releasing too soon and the cycle stop latch, 725C, not locating in front of the rock lever, 722, on the 12-70 connecting link.

The lost motion between the roller on the flexible end for the over-carry trip 9-1278 which is designated as W, and the lifter assembly, 9-30, shown as V in figure 4, plate 9, of Machine Service Bulletin #108, must be eliminated so that the 9-1278 will trip faster.

To remedy this, bend the offset arm of 9-1278 downward so that no play exists between roller W and lifter V. Change springs 685 and 787 $\frac{1}{4}$  as outlined in Machine Service Bulletin #112A.

To prevent the machine locator arm, 9-1260, from releasing from the rock lever and connecting link, 12-70, too soon when the shift keys are operated, we are bevelling the connecting link and under-cutting the flexible end of the 9-1260. This gives the cycle stop latch, 725C, more time to drop in front of the rock lever, 722.

These parts cannot be ground by servicemen in the field as it necessitates locating them in a special fixture for grinding to the accuracy required. We, therefore, request that when this change is necessary new parts be substituted and the original parts be returned to us. After the parts are installed check their functioning as follows:

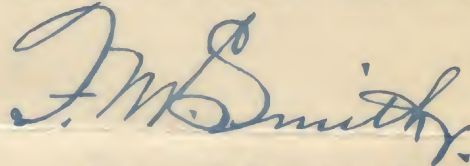
Neutralize the mechanism and cut off the power. Revolve the carrying shaft by hand rearward until the rock lever and connecting link, 12-70, takes up the gap completely between the flexible end of the machine locator arm and the blank, 1224 $\frac{1}{4}$ , on the connecting link. Hold the carrying shaft in this position and depress either shift key, then slowly release the carrying shaft and note if the cycle stop latch, 725C, drops in front of the 722 rock lever on the 12-70 connecting link before the machine locator arm, 9-1260, releases.



Caution: The 9-1260 should not release before the 725C; however, if they both release together it is satisfactory.

If the 9-1260 does release too early peen blank 1224 $\frac{1}{2}$  on machine locator arm, 9-1260, carefully. This will decrease the gap and shorten the oscillation of the rock lever, 722. This also allows the cycle stop latch, 725C, to engage the rock lever 722 earlier.

Material required may be requisitioned in the regular way and all material returned will be credited to offset the charge for the new parts.

A handwritten signature in blue ink, appearing to read "J. M. Smith". The signature is fluid and cursive, with a large initial "J" and "M".

FMS:GBC

General Service Manager

Toledo, Ohio.

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